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D205-541-055
Job Sheet 175153



Part No: D205-541-055

Job Qty: 1 ea

Part Name: Bell Medium Basket Quick Release Retrofit



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/28/18

Job Tracking No:

Due Date: 4/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 16.12.06 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/2/18	4/2/18	0.00	0.00	Start Up Stores/Pkg-1		<i>DAS</i> <i>MAR 28 2018</i>
110	Packaging	1 pcs	4/2/18	4/2/18	0.00	0.00	Packaging1-2		<i>DAS</i> <i>MAR 28 2018</i>
120	QC	1 pcs	4/2/18	4/2/18	0.00	0.00	QC4		<i>9:59</i> <i>Smb</i>
125	DC	1 pcs	4/2/18	4/2/18	0.00	0.00	DC		<i>Smb</i>
130	Packaging	1 pcs	4/2/18	4/2/18	0.00	0.00	Packaging3-1		<i>Smb</i>
140	QC21-FG	1 Ea	4/2/18	4/2/18	0.00	0.00	QC21		<i>DAS</i> <i>21</i> <i>9:59</i> <i>APR 03 2018</i>

Part Op 125 - Photocopy bluefile & type labels per PPP D205-541-055 CHG001

Descriptions: 130 - Identify and pack for shipping as per PPP D205-541-055

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2690-6	Lanyard	3 Ea (3 ea)	90-Start up Operation	<i>5053681</i>
D5407-041	Strut Assembly	1 Ea (1 ea)	90-Start up Operation	<i>8147174</i>
D5407-043	Strut Assembly	1 Ea (1 ea)	90-Start up Operation	<i>86155833</i>
D5407-045	Strut Assembly	1 Ea (1 ea)	90-Start up Operation	<i>1158887</i>
D5457-1	Mounting Lug	1 Ea (1 ea)	90-Start up Operation	<i>8154746</i>
D5458-1	Bushing	2 Ea (2 ea)	90-Start up Operation	<i>1154444</i>
MS17984-C411	Quick Release Pip Pin	1 Ea (1 ea)	90-Start up Operation	<i>804136295</i>
MS17984-C413	Quick Release Pin	1 pcs (1 ea)	90-Start up Operation	<i>8541163</i>
MS17984-C510	Pin, Quick Release	1 Ea (1 ea)	90-Start up Operation	<i>8019429</i>
NAS1149D0416J	Washer	3 Ea (3 ea)	90-Start up Operation	<i>81131571</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2690-6	3	93	0
	D5407-041	1	4	0
	D5407-043	1	6	0
	D5407-045	1	4	0
	D5457-1	1	7	0
	D5458-1	2	12	0
	MS17984-C411	1	5	0
	MS17984-C413	1	50	0
	MS17984-C510	1	7	0
	NAS1149D0416J	3	3,200	0

2047

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I

Part Specifications

Specifications could not be found.

Plex 3/28/18 8:11 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

3.0 300 HOUR INSPECTION

Update 300 Hour inspection in ICA-D205-541 to include the following items:

- 3.1 All visible areas of the installation should be checked for mechanical damage (scratches, nicks, wear) and corrosion according to Table 1. Replace parts that have been damaged beyond limits.
- 3.2 Inspect the condition of the hardware for suitability for continued service.

Table 1 - Damage Limits

Location	Type of Damage	Max. Allowable Damage	Repair
D5407-041/-043/-045 Strut Assembly D5457-1 Mounting Lug	Nicks, Scratches, Corrosion	Up to 0.010" (0.25 mm) deep	Acceptable. Polish out to a maximum depth of 0.010" (0.25 mm) using scotchbrite
		Over 0.010" (0.25 mm) deep	None, replace part
	Elongated Holes	Up to 0.025" (0.64 mm) across hole diameter	Acceptable
		Over 0.025" (0.64 mm) across hole diameter	None, replace part
	Cracks/Dents/Bending/Yielding	None	None, replace part

4.0 WEIGHT AND BALANCE

The net weight and balance for the D205-541-051 Quick Release Retrofit kit is shown in the table below:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-055 Quick Release Retrofit kit	1.46 lb 0.66 kg	48.50 in 1.23 m	70.8 in-lb 0.81 m-kG	118.80 in 3.02 m	173.4 in-lb 1.99 m-kG

5.0 PARTS LIST

Qty -055	Part Number	Description
X	D205-541-055	QUICK RELEASE RETROFIT
3	D2690-6	LANYARD ASSEMBLY
1	D5407-041	STRUT ASSEMBLY
1	D5407-043	STRUT ASSEMBLY
1	D5407-045	STRUT ASSEMBLY
1	D5457-1	MOUNTING LUG
2	D5458-1	BUSHING
1	MS17984-C411	PIP PIN
1	MS17984-C413	PIP PIN
1	MS17984-C510	PIP PIN
3	NAS1149D0416J	WASHER

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9747	SHEET 2 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	QUICK RELEASE RETROFIT	NTS
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